

Work Order ID 72797

Monday, August 15, 2011 10:02:40 AM



Page 1

Accept



Setup Start



Stop

[illegible]

Customer:

[illegible]

Run Start

**Tooling:**

Date:

Stop



SPC (Y/N):

Date:

**Insp.
Stamp**

Revision Nbr

D3929

A

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-14

131-8-16

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72797

Monday, August 15, 2011 10:02:40 AM



Page 2

Item ID:	D3929-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gusset Assembly					
Start Date:	8/15/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/19/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5 wash 116					
140 Large Fab Large Fab	Weld bushings D3907-1 as per dwg D3929 316L rod batch: <u>M114649</u>	0.00 0.00							<u>Pl 11.08.23</u> <u>PMB</u> <u>11/08/23</u>
150 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		BE K 11.08.24		6	8		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, August 15, 2011 10:02:40 AM



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Item ID:	D3929-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gusset Assembly					
Start Date:	8/15/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/19/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/15/24		(X6) (2178)			
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA 6/5</u> Memo	0.00 0.00				PL 11-09-06		(X6)	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/9/06 MEF 11-09-06

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, August 15, 2011 10:02:27 AM

Page 1

Work Order ID: 72797

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 8/15/2011

Required Date: 8/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	62.5000	0.45	2.842105			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		62.5							
				117494		62.5							
D3907-1  Bushing		Manufactured	No			130	Each	69.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		65							
				70673		25							
				72317		40							
				WA005		4							
				65920		4							

B11-8-16

117494

PNB

11/08/23

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

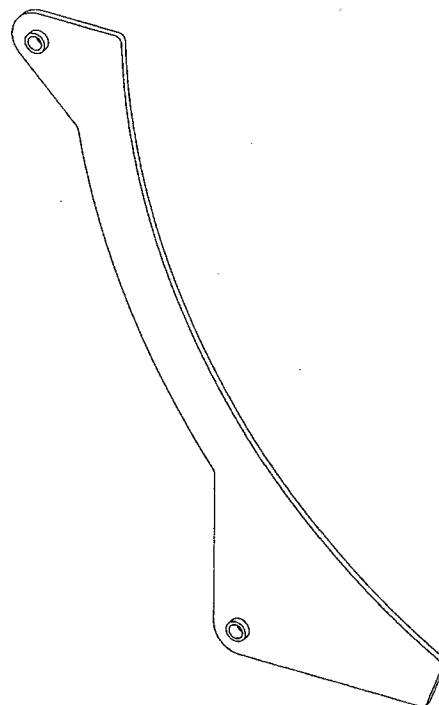
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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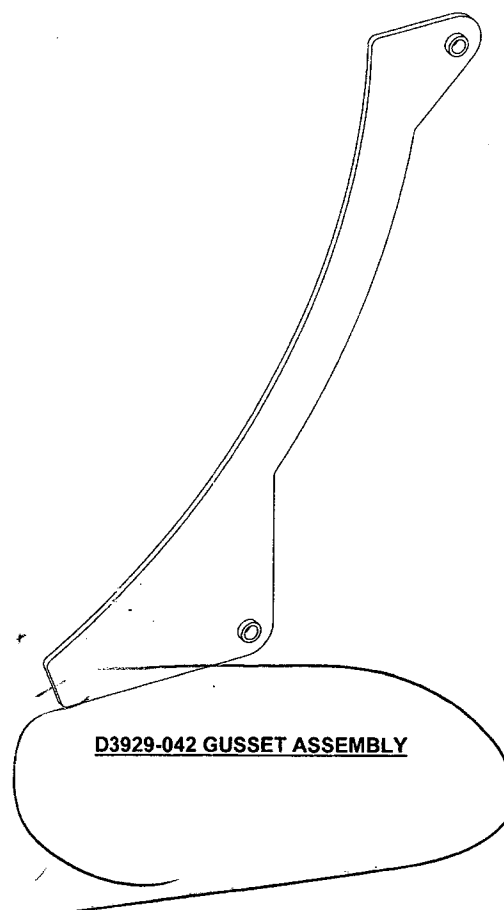
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
8/6/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A
TITLE GUSSET ASSEMBLY	SHEET 1 OF 3
SCALE NTS	
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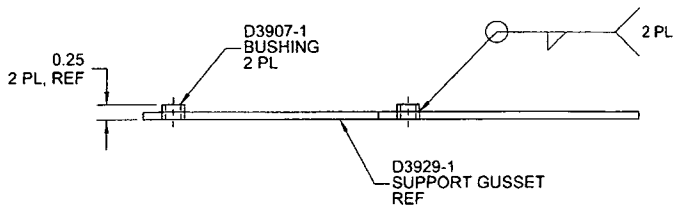
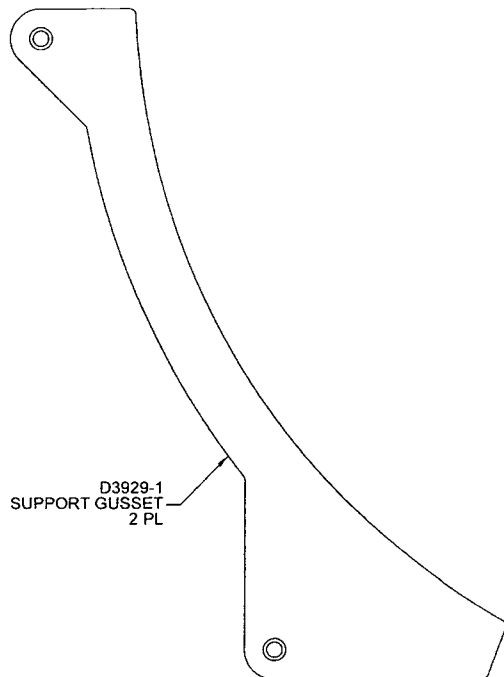
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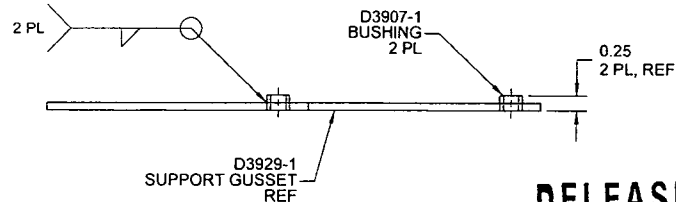
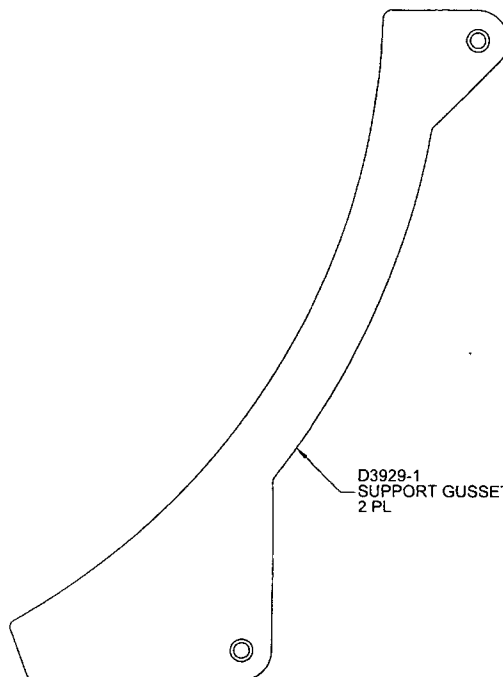
D3929-041 GUSSET ASSEMBLY

D

C

B

A



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22 MD

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8 7 6 5 4 3 2 1

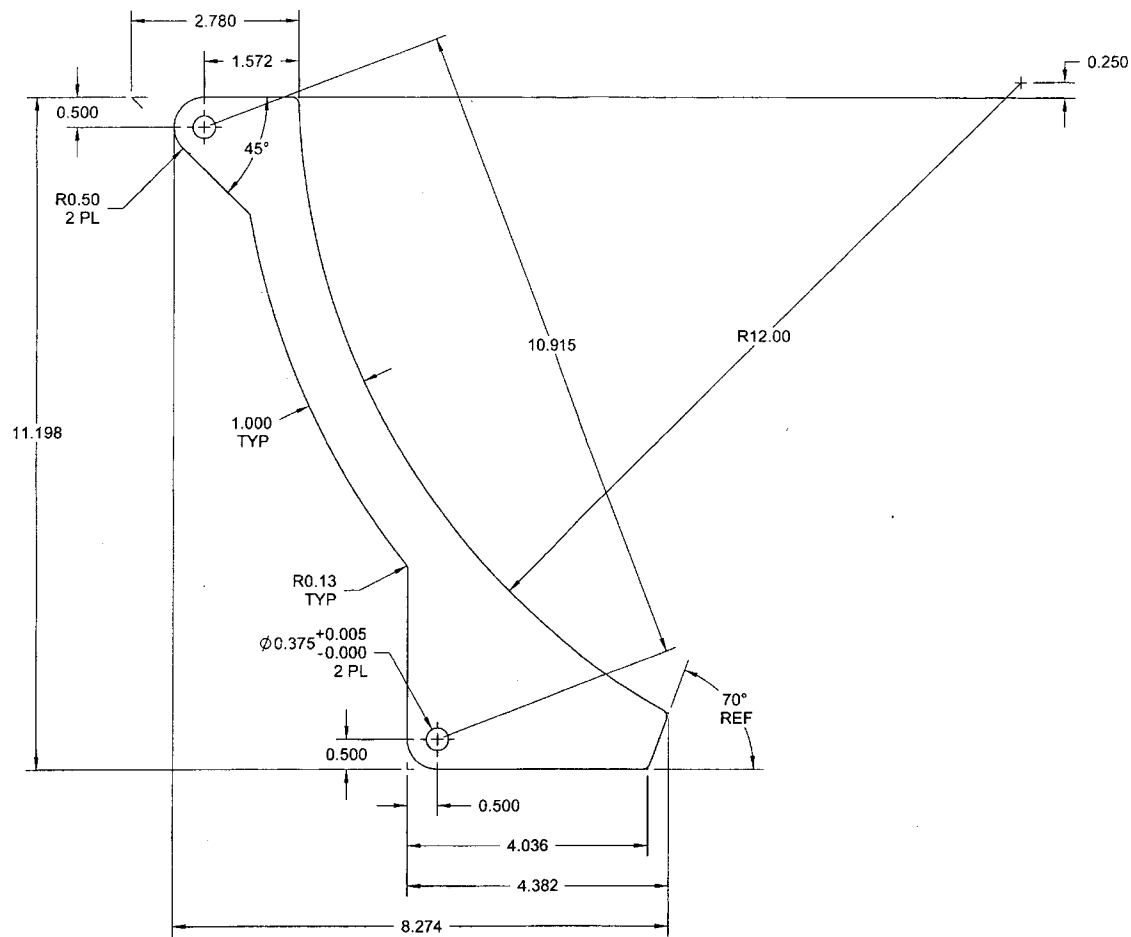
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
09/04/22

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